

Work Order ID 61934

Friday, September 10, 2010 9:14:28 AM

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PRELIMINARY ISSUE

Item ID: D4172-041

Accept

Revision ID: PRELIM

Item Name: Pod Mounting Frame Assembly

Start Date: 9/10/2010 Start Qty: 1.00

Required Date: 9/17/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4172

PAT PA2

10-09-16

0.00

100



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

RT 10-09-22

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

10-09-23
to PA2

0.00

Test fitted in the
pack. Fits good.
transfer drilling was
good.

10-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61934

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Item ID:	D4172-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pod Mounting Frame Assembly					
Start Date:	9/10/2010	Start Qty:	1.00			
Required Date:	9/17/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 112588</i> Memo *** Mask prior to powdercoat as per notes. *** Start Time: <i>9:55</i> Oven Temperature: <i>320°</i> Finish Time: <i>10:25</i>	0.00 <i>BL 10-9-23.</i>				<i>1</i>	<i>0</i>		
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>34 10/9/23</i>				<i>1</i>	<i>0</i>		
140 Packaging Packaging	Identify as per dwg & Stock Location: <i>composites</i> Memo	0.00 <i>47 10-09-28</i>				<i>47</i>	<i>10-09-28</i>	<i>81</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61934

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Item ID: D4172-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod Mounting Frame Assembly

Start Date: 9/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29

10-09-23

POSITIVE RECALL

EFFECTIVE 10-09-13

AUTH

RELEASED

DATE 10-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 10, 2010 9:14:35 AM

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Work Order ID: 61934

Parent Item: D4172-041

Parent Item Name: Pod Mounting Frame Assembly

















Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-043  Z-Shape Section Assembly, LH		Manufactured	No			100	Each	0.0000	1	1			
						B61935						RT 10-09-22	
D4172-044  Z-Shape Section Assembly, RH		Manufactured	No			100	Each	0.0000	1	1			
						B61936						RT 10-09-22	
D4172-047  Crossbar Assembly		Manufactured	No			100	Each	0.0000	5	5			
						B61937						RT 10-09-22	
D4180-1  Gusset		Manufactured	No			100	Each	0.0000	1	1			
						B61924						RT 10-09-22	
D4180-2  Gusset		Manufactured	No			100	Each	0.0000	1	1			
						B61927						RT 10-09-22	
D4180-3  Gusset		Manufactured	No			100	Each	0.0000	1	1			
						B61925						RT 10-09-22	
D4180-4  Gusset		Manufactured	No			100	Each	0.0000	1	1			
						B61928						RT 10-09-22	
D4180-5  Gusset		Manufactured	No			100	Each	0.0000	1	1			
						B61926						RT 10-09-22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 10, 2010 9:14:36 AM

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Work Order ID: 61934



Parent Item: D4172-041



Parent Item Name: Pod Mounting Frame Assembly

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D4180-6	Manufactured	No	100	Each	0.0000	1	1
							BT 10-09-22
Gusset							
D4181-1	Manufactured	No	100	Each	0.0000	1	1
							BT 10-09-22
Pod Frame Platform							
CR3213-4-04	Purchased	No	100	Each	0.0000	38	38
							BT 10-09-22
Rivet							
CR3213-4-06	Purchased	No	100	Each	0.0000	24	24
							BT 10-09-22
cherry rivet							
MS24694-5100	Purchased	No	100	Each	0.0000	4	4
							BT 10-09-22
Screw, Flat Head							

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

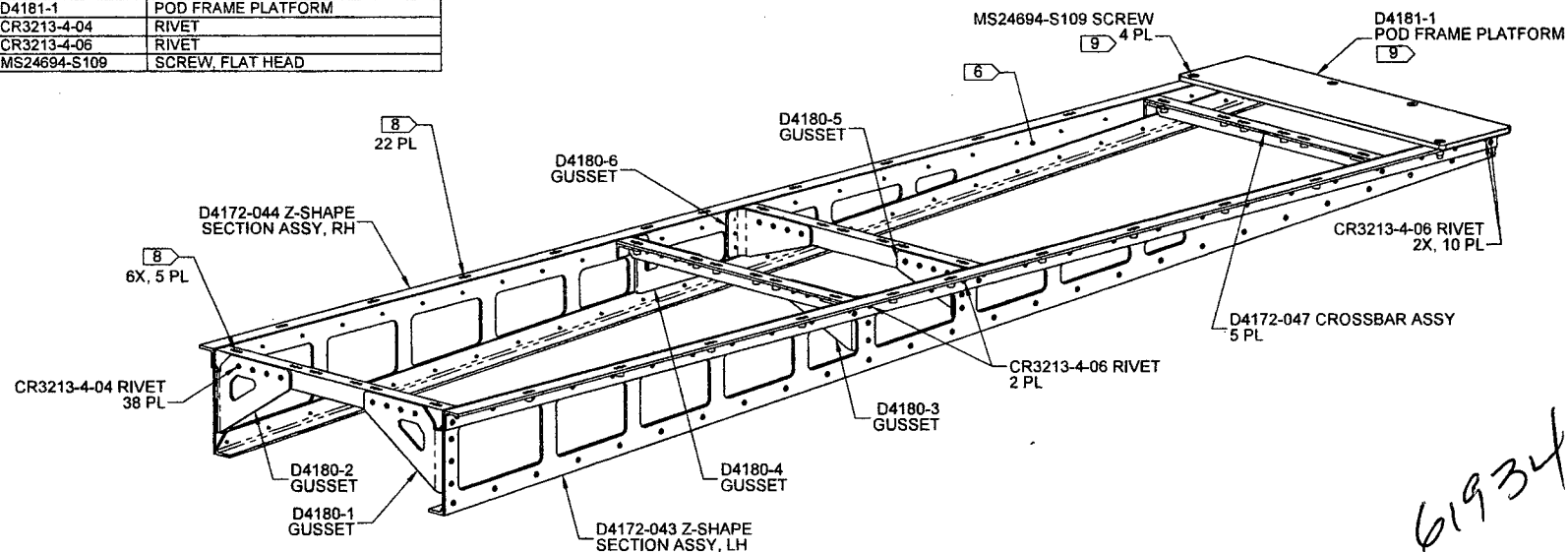
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S109	SCREW, FLAT HEAD



D4172-041 POD MOUNTING FRAME ASSY

PRELIMINARY ISSUE
10.09.15

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 8.26 lbs
- 8) MASK PRIOR TO POWDER COATING
- 9) INSTALL AFTER POWDER COATING

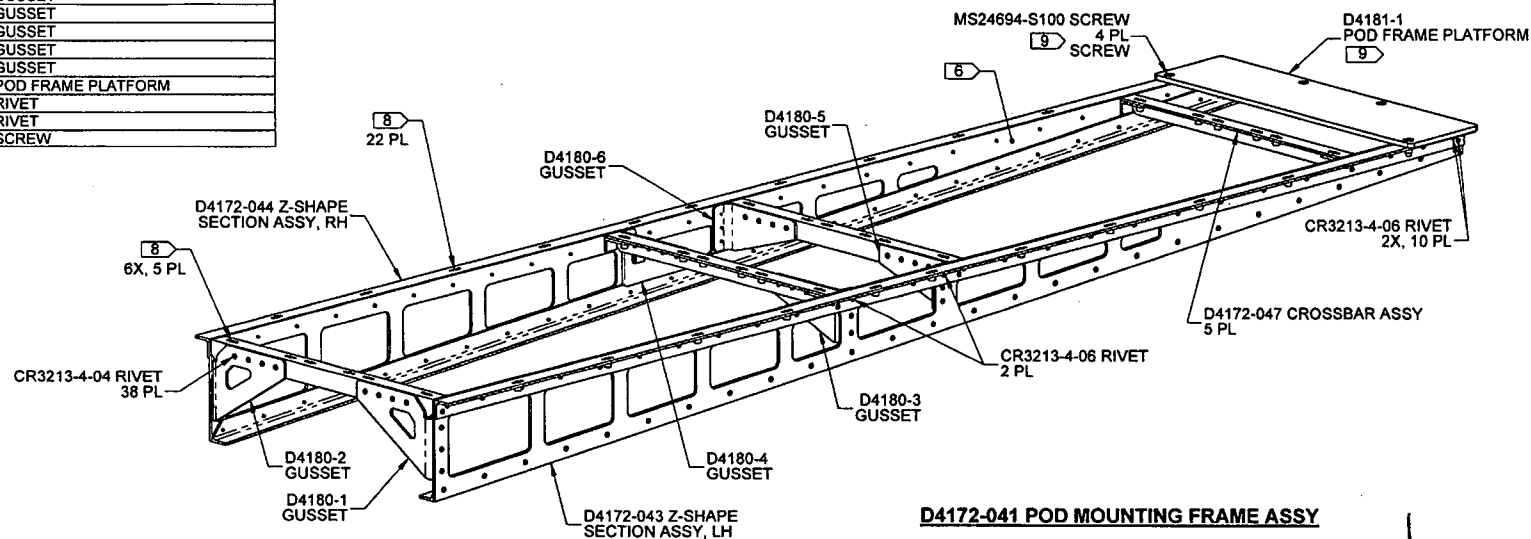
PA2	D4172-6 REPLACED BY D4172-5; REMOVE Ø0.257 HOLES ON D4172-5; 8 SHT DWG NOW 7 SHT.	MB	10.09.15
PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

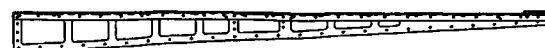
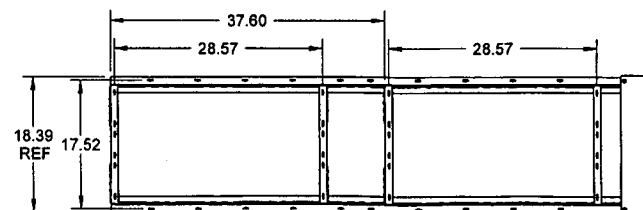
DRAWING NO. REV. PA2
D4172
SHEET 1 OF 7
TITLE SCALE
POD MOUNTING FRAME ASSY NTS

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW



D4172-041 POD MOUNTING FRAME ASSY



SUPPLEMENTAL VIEWS

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
 - 7) WEIGHT: 15.0 lbs
 - 8) MASK PRIOR TO POWDER COATING
 - 9) INSTALL AFTER POWDER COATING

RELEASED
2010-09-29

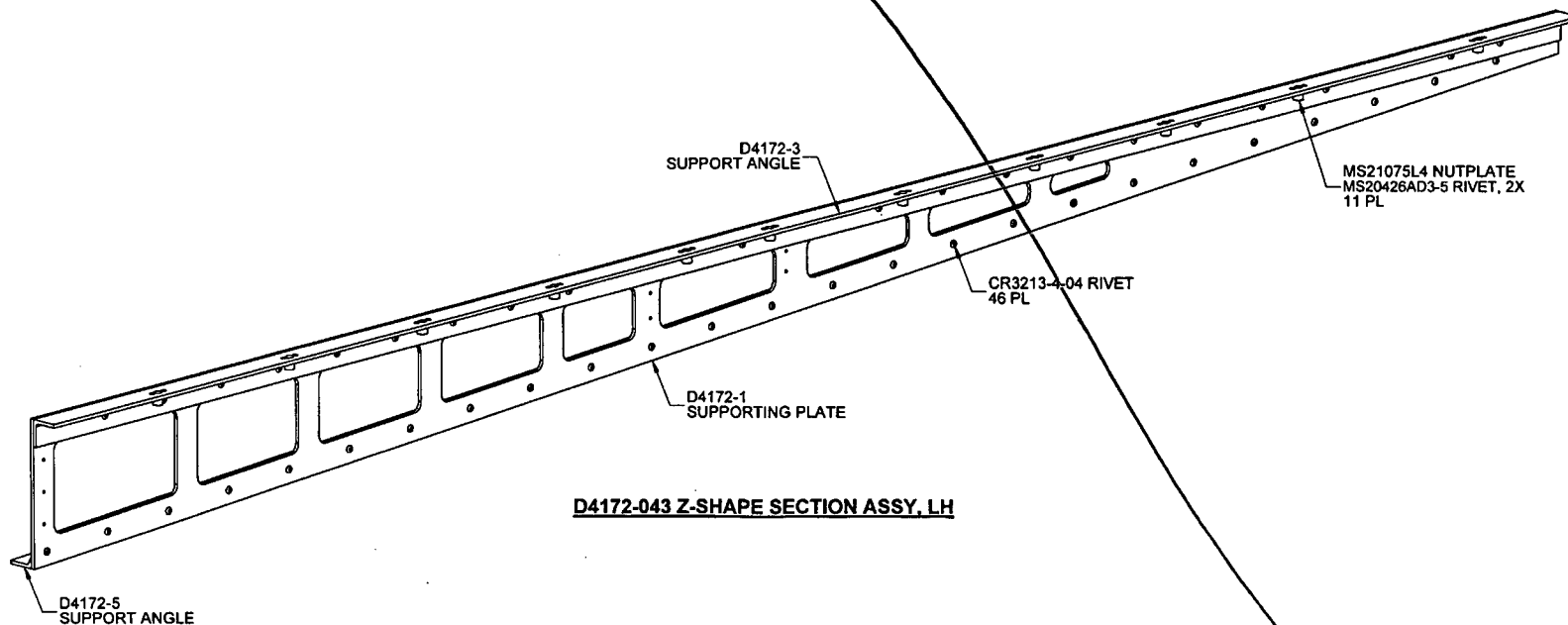
REV.	NEW ISSUE	DESCRIPTION	MB	10.09.15
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.09.15			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4172** REV. A
SHEET 1 OF 7
SCALE
TITLE **POD MOUNTING FRAME ASSY** NTS

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



D4172-043 Z-SHAPE SECTION ASSY, LH

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4172	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2010-09-29